

Work Order ID 78536

January-11-12 8:40:05 AM

Now

78536

Page 1

Item ID: D3255-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 1/11/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/11/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3255								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B 12-1-11

(12)

B 12-1-11

Work Order ID 78536

78536

Page 2

January-11-12 8:40:05 AM

Item ID: D3255-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Gasket

Stop ***NS2***

Start Date: 1/11/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/11/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sizelick

(412)

130

Identify as per dwg & Stock Location: *G.A*

0.00

130

Packaging

Memo

0.00

Packaging

EP 12/01/12 (18)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/11/12 J

MUF 12-01-12

Picklist Print

January-11-12 8:40:04 AM

Page 1

Work Order ID: 78536

Parent Item: D3255-5

Parent Item Name: Gasket

Start Date: 1/11/12

Required Date: 1/11/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.05.12New issueKJ/RF
IPP Rev:B Now On Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255 Gasket		Manufactured	No			110	sf	61.5000	1.5411	16.222105			

12-1-11

Location	Loc Qty	Loc Code
MAT052	3	
44088	3	
ST412	58.5	
63846	4.5	
75946	54	

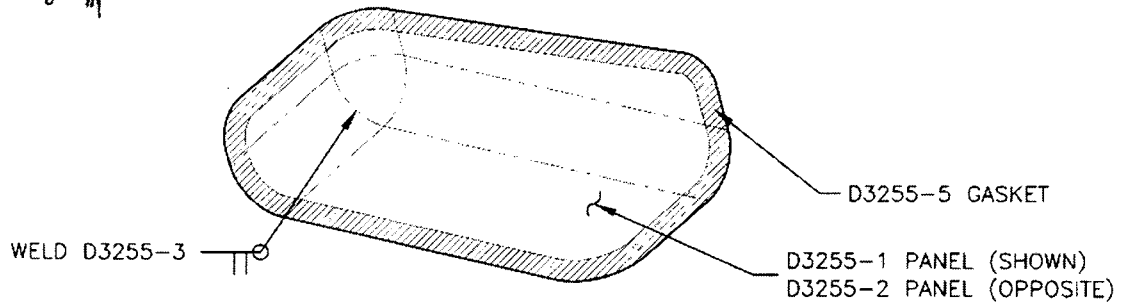
75946

12

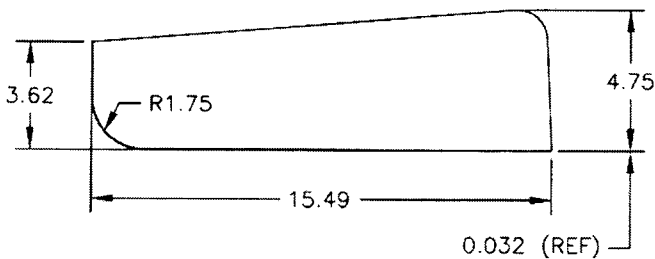
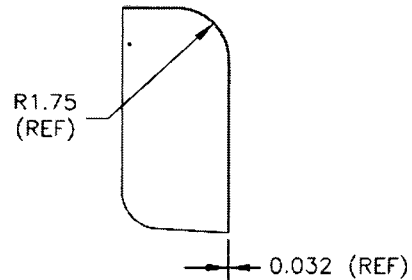
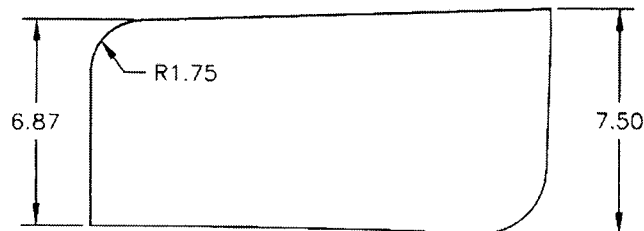


DESIGN P4	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

w/078536

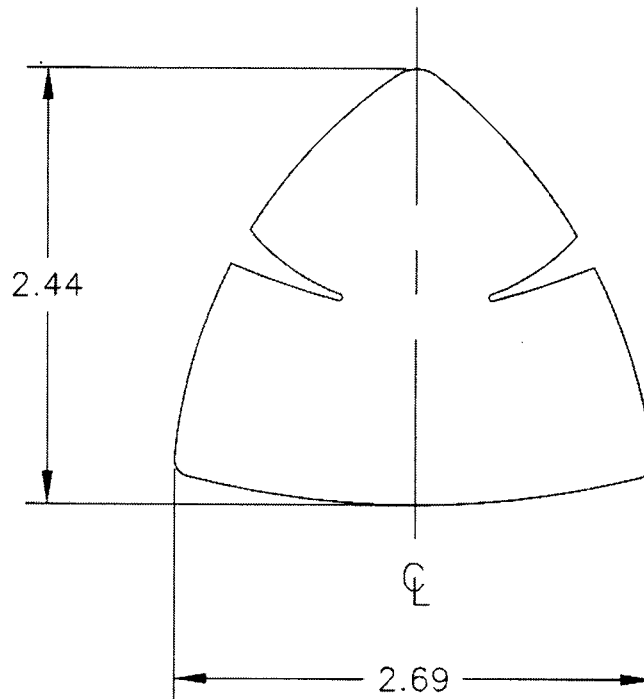
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DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JH	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-08 JH



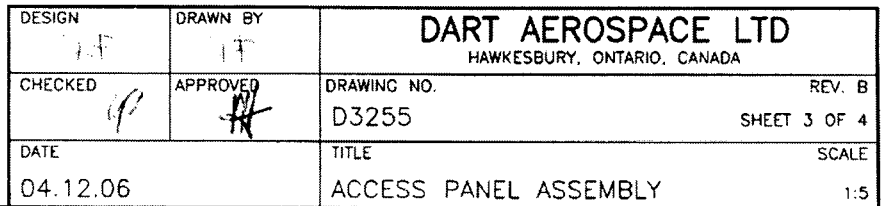
D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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Technical drawing of a mechanical part with dimensions and tolerances. The drawing shows a cross-section of a part with a central rectangular feature and rounded corners. Key dimensions and tolerances include:

- Overall width: 18.456
- Overall height: 11.432
- Top-left corner radius: R1.00
- Top-right corner radius: R1.25
- Bottom-left corner radius: R2.20
- Top edge chamfer: 15.171
- Top edge chamfer radius: R0.13 $^{0.00}_{-0.03}$
- Top edge chamfer width: 2.261
- Top edge chamfer angle: 2° (TYP)
- Top edge chamfer width: 1.188
- Top edge chamfer width: 1.183
- Top edge chamfer width: 2.261
- Top edge chamfer width: 0.250
- Top edge chamfer width: 0.250
- Top edge chamfer width: 6.902
- Top edge chamfer width: 10.032
- Top edge chamfer width: 2.363
- Top edge chamfer width: 2.363
- Top edge chamfer width: 6.93
- Top edge chamfer width: 1.432
- Top edge chamfer width: 0.098 (B)

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

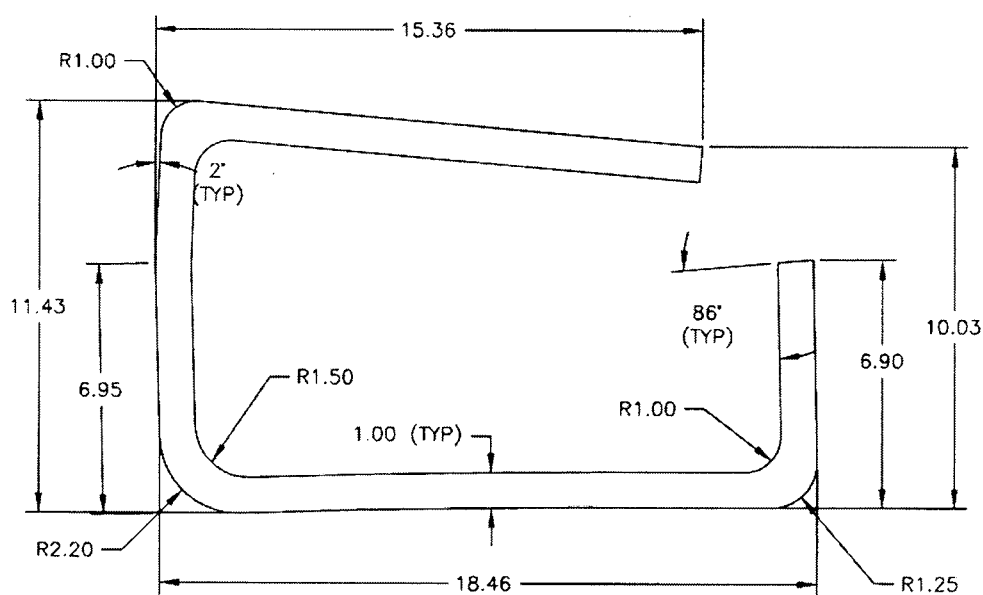
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CHECKED LP	APPROVED #	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RECEIVED
05 01 18 #



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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